

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D120-639 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D120-639 REV. 0

REF TCCA STC: SH01-25
REF FAA STC: SR01347NY
REF EASA STC: EASA.IM.R.S.01452

1.0 PURPOSE

It has come to Dart's attention that the D120-639-011/-013 Wearplate Kits can't be installed as intended on recent EC 120B aircraft due to a Eurocopter design change on the spring blade located at the aft end of the skidtube. This Dart Service Instruction (DSI) introduces the new D120-639-021 Wearplate Kit (fits one skidtube) for customers with aircraft equipped with the new style spring blades. The D120-639-021 Wearplate Kits should be installed in pairs (one per skidtube).

2.0 INSTALLATION

- 2.1 Remove existing wearplates and plug all unused holes with the screws that were just removed.
- 2.2 Remove and retain DHS411-101-2076 Bolt and associated hardware securing the spring blade per aircraft maintenance manual.
- 2.3 Locate D4677-1 Wearplate using DHS411-101-2076 Bolt removed at Step 2.2 as shown in Figure 1 of this service instruction. Locate D2746 and D2656-13 Wearplates as shown in Figure 1. Adjust the amount of overlap between the wearplates to ensure that the wearplate holes do not interfere with any existing holes in the skidtube. Temporarily clamp the wearplates into the proper position.
- 2.4 Using the wearplates as a template, drill $\varnothing 0.125$ holes in the center of the wearplate obrounds. To help maintain position of the wearplates during the drilling operation, it is recommended to cleco the wearplates to the skidtube as the pilot holes are drilled. Remove wearplates after all pilot holes are drilled.
- 2.5 Open holes drilled in previous step to $\varnothing 0.297$ and deburr. Remove swarf from inside of skidtube. Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install ALS7-1032-130 inserts.
- 2.6 Install the D2656-13, D2746, and D4677-1 Wearplates and D2648-3 Wearpads using the MS27039-1-08 Screws and NAS1149D0332J Washers. Seal all screws with Sikaflex-241/291 (or Proseal 890) sealant before installing. Re-install the DHS411-101-2076 Bolt and associated hardware and torque to 44.3-61.9 in-lb (5.0 7.0 N-m). Note: It is acceptable to omit the washer(s) on DHS411-101-2076 Bolt to ensure 1.5-4 threads in safety. It is acceptable to trim the D4677-1 Wearplate as required to clear the aft saddle.
- 2.7 Adjust weight and balance in accordance with Section 4.0 below.

3.0 MAINTENANCE

Maintain the D120-639-021 Wearplate Kit in accordance with ICA-D120-639 Rev. 0 or later approved revision.

4.0 WEIGHT AND BALANCE

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D120-639-021 WEARPLATE KIT	3.2 lb 1.5 kg	136.0 in 3.45 m	435 in-lb 5.2 m-kg	± 40.7 in ± 1.03 m	± 130 in-lb ± 1.5 m-kg

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH01-25
ISSUE NO.: 1

A	NEW ISSUE	MB	12.06.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9623	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE KIT	NTS
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5.0 PART LIST

Qty -021	Part Number	Description
X	D120-639-021	WEARPLATE KIT
5	D2648-3	WEARPAD
1	D2656-13	WEARPLATE
1	D2746	WEARPLATE
1	D4677-1	WEARPLATE
38	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
38	MS27039-1-08	SCREW
38	NAS1149D0332J	WASHER

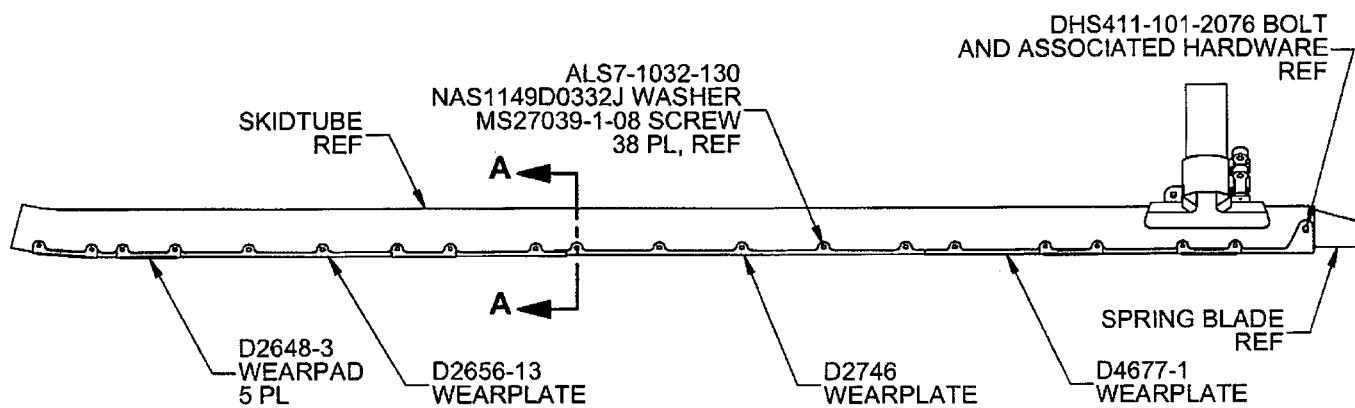
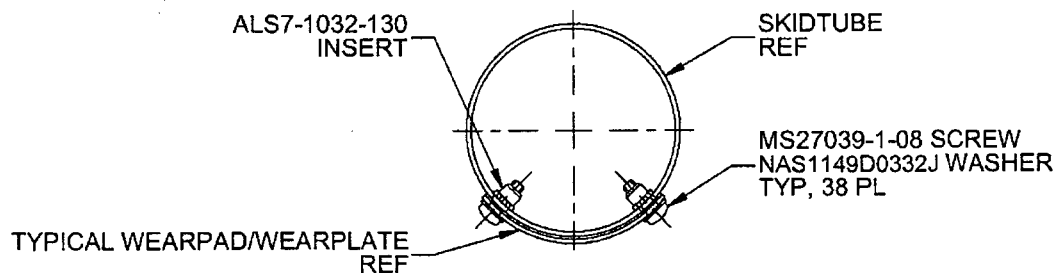


FIGURE 1: D120-639-021 WEARPLATE KIT INSTALLATION



SECTION A-A: TYPICAL SKIDTUBE SECTION

SCALE 4X

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MFG. APPR.	N/A		SHEET 2 OF 2
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